

# Work Order ID 56780

March 10, 2010 7:21:47 AM



Page 1

Item ID: D3467-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover Plate Assembly LH

Start Date: 3/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3467

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3467 2-Spot Weld as per Dwg D3467 and Dart QSI  
004 13-Identify as D3467-047

7m-k

10/03/10

(IX)

110

QC11- Inspect spot weld per QSI004

0.00



QC

Memo

0.00

Quality Control

80 10/03/10

(U)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.0/03/10

(H/LH)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56780

March 10, 2010 7:21:47 AM



Page 2

Item ID: D3467-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover Plate Assembly LH

Start Date: 3/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

*JS 10/03/10 @*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/11 JF*  
*MF 10-3-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 10, 2010 7:21:46 AM

Page 1

Work Order ID: 56780

Parent Item: D3467-047

Parent Item Name: Cover Plate Assembly LH

Start Date: 3/10/10

Required Date: 3/15/10

Comments: IPP Rev: A New Issue 06-04-24 EC  
IPP Rev: B As per Rev B 06-05-24 JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3467-1

Manufactured

No



Cover Plate LH



*EP 10/03/10*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

55948

3

Each

4.0000

1.0000



*EP 10/03/10*

D3467-7

Manufactured

No



Seal Strip

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST059

4

36104

4

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

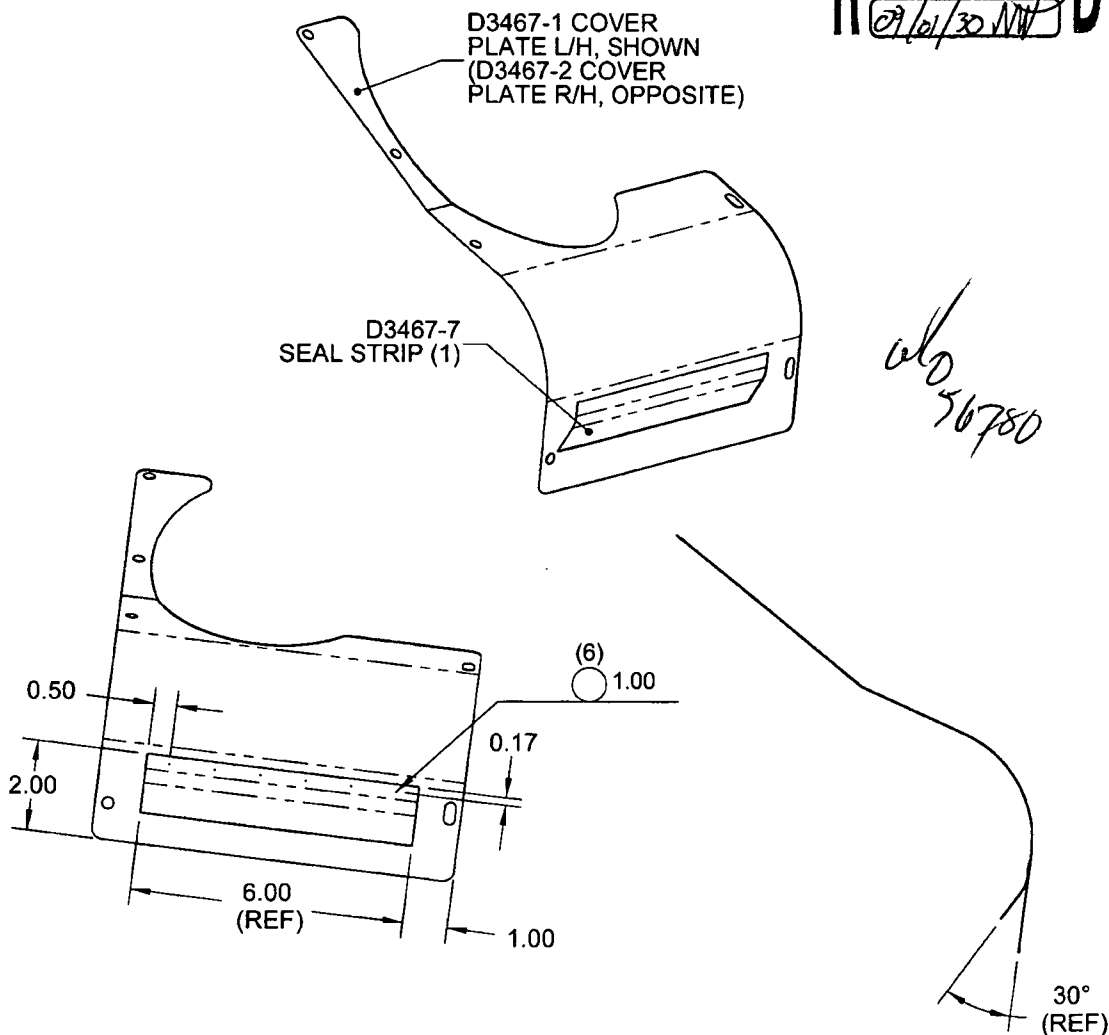
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 4 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED  
*07/01/30 MW*



**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 73

EMPLOYEE: Maue Gregory

PART NUMBER: D 3467-047

JOB NUMBER: B 56700

MATERIAL TYPE: \_\_\_\_\_

MATERIAL THICKNESS: \_\_\_\_\_

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium <sup>SS</sup>

## TEST RESULTS

	PASS	FAIL	
VISUAL:	[ <u>/</u> ]	[   ]	
PENETRATION:	[ <u>/</u> ]	[   ]	
PULL STRENGTH:	[ <u>/</u> ]	[   ]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/03/10

QUALIFIER: SB